

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022782**Date Inspected:** 03-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Guo Xing Hui		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No
Component:	OBG	

Bridge No: 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as An Qing Xiang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Anchor Plate Deck

PCMK: SEG3020AQ

Weld Number: 025

Welder: 066398

WPS-B-P-2211-TC-U4b-FCM-1

Component: Anchor Plate Deck

PCMK: SEG3020AQ

Weld Number: 025

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welder: 067611
WPS-B-P-2211-TC-U4b-FCM-1

Component: Anchor Plate Deck
PCMK: SEG3020BB
Weld Number: 047
Welder: 067829
WPS-B-P-2211-TC-U4b-FCM-1

Bay 16

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08723 from ZPMC for Bay 16. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The segment is identified as Steel Barrier. The weld designations reviewed are as follows.

W5-SB33A-001
W5-SB31-002
W5-SB32A-001
W5-SB30-001
W5-SB30-002

This QA Inspector observed the following work in progress for Bay 16.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Ma Qian Li.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Component: Steel Barrier
PCMK: E2-SB26A-001
Weld Number: 114
Welder: 201861
WPS-345-SMAW-2F-Repair
WR 20446

Bay 19

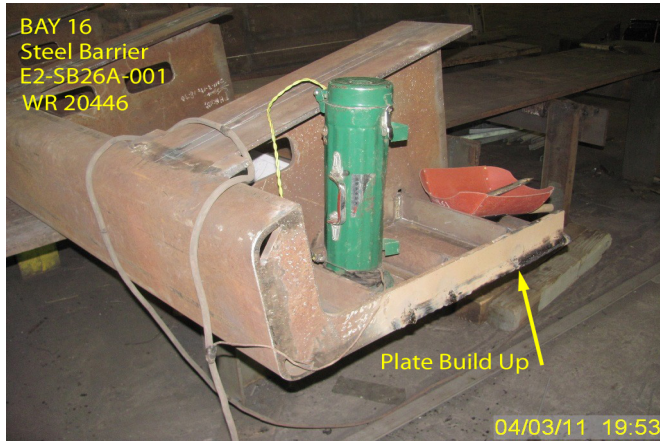
Heat straightening of PCMK, SA6529 under approved Heat Straightening procedure, HSR 10216. The in process temperature was observed as 250°C. The ZPMC QC was identified as Ma Qian Li. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 6mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis
----------------------	--------------

Quality Assurance Inspector

Reviewed By:	Riley,Ken
---------------------	-----------

QA Reviewer
